

Work Order ID 62318

September 27, 2010 10:24:27 AM

*Handwritten: K&L*  
**PRELIMINARY ISSUE**

OK to D4132-Rev.A *Handwritten: 9/16.09.29*

Page 1

Item ID: D4132-041

Accept

Revision ID:

Item Name: Wearplate. LH Fwd

Start Date: 9/27/10 Start Qty: 4.00

Required Date: 9/29/10 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: *Handwritten: W*

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4132

pb2

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut D4132-1F as per Dwg D4132

Dwg Rev: *Handwritten: pb2*

Prog Rev: *Handwritten: pb2*

2-Deburr if necessary

*Handwritten: B 10-9-27*

*Handwritten: (2) (3)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*Handwritten: B 10-9-27*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*Handwritten: B 10-09-27 (2) (3)*

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Page 2

Item ID: D4132-041

Accept



Setup Start



Revision ID:

Stop



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Start Date: 9/27/10 Start Qty: 4.00



Cust Item ID:

Required Date: 9/29/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

130

Form as per dwg  
NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

1- Form using DT \_\_\_\_\_ Die as per Dwg D4132

AB 10-09-27 (3)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

CP 10-09-28 (3)

150

Weld per dwg A/R Hardcoat S.S. Batch:

0.00

Large Fab

M 115553



Large Fab

Memo

0.00

Large Fab

Weld hard surface using DT \_\_\_\_\_ as per QSI 004 and Dwg D4132\_

AB 10/09/28 (3x)

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Setup Start

Stop

Start Date: 9/27/10 Start Qty: 4.00

Required Date: 9/29/10 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00 - inspected to PB2

Day only

0.00

8/26/29 x3

QC

Memo

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

10-09-29 (3)

0.00

QC

Memo

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

10-9-29

0.00

Powdercoat

Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00  
320°  
8:30

(3)

**Work Order ID 62318**

September 27, 2010 10:24:28 AM



Page 4

Item ID: D4132-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate, LH Fwd

Start Date: 9/27/10 Start Qty: 4.00



Cust Item ID:

Required Date: 9/29/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC3- Inspect Part Finish

0.00

=&gt; H1

10/09/29

3

Ø

QC

Memo

0.00

Quality Control

200

0.00

Small Fab

Memo

0.00

Small Fab

I- Bond D4132-3 gasket to inner surface of wearplate using a thin layer of 3M  
1300/1300L scotch grip adhesive  
Batch: M113174

SP 10/09/29

③

210

QC5- Inspect part completeness to step on W/O

0.00

10.09.29 ③

QC

Memo

0.00

Quality Control

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Required Date: 9/29/10 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

220

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Packaging

Memo

0.00

Packaging

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 09.27 AUTH [Signature]  
RELEASED CR DATE 10.09.29

# Picklist Print

September 27, 2010 10:24:26 AM

Page 1

Work Order ID: 62318

Parent Item: D4132-041

Parent Item Name: Wearplate, LH Fwd



Start Date: 9/27/10

Required Date: 9/29/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4132-3 		Manufactured	No			200	Each	1.0000	1	4		SB 10/09/29	(3)
Gasket													

Location	Loc Qty	Loc Code
GA 862317	1	(3)
60303	1	

M304S18GA 		Purchased	No			100	sf	109.9479	1.555	6.547368		9.4	
304/316 .050 Sheet												10-9-27	

Location	Loc Qty	Loc Code
MAT20	109.9479	
111743	7.36	
112885	10.4179	
113062	40.17	
115389	52	

112885

(6)

DART AEROSPACE LTD		Work Order: 62318
Description: WEAR PLATE L.H. FWD		Part Number: D4132-041
Inspection Dwg: D4132-1 Rev: pb2		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .203	+ .005 - .001	.204	✓		V 1802	
.450	± .00	.450	✓		V	
.300	± .010	.301	✓		V	
.490	± .00	.487	✓		V	
1.25	± .030	1.25	✓		V	
2.89	± .030	2.886	✓		V	
5.280	± .010	5.281	✓		V	
5.77	± .030	5.769	✓		V	
8.20	± .030	8.195	✓		V	
.375	± .010	.375	✓		V	
1.92	± .030	1.917	✓		V	
5.024	± .010	5.025	✓		V	
9.774	± .010	9.774	✓		T 1861	
11.92	± .030	11.92	✓		T	
14.448	± .010	14.448	✓		T	
19.278	± .010	19.278	✓		T	
21.92	± .030	21.92	✓		T	
23.613	± .010	23.613	✓		T	
27.953	± .010	27.953	✓		T	
.050	± .010	.050	✓		V	

Measured by: 18	Audited by: 18	Prototype Approval:	N/A
Date: 10-9-07	Date: 10-09-27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O: 62318		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.09.29	100	Acceptable to D4132 Rev.A <del>REF</del> REF ATTACHED EMAIL	GP	10.09.29		10.09.29 QSI 042	

Part No: D4132-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## Chris Provencal

---

**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** September 29, 2010 2:19 PM  
**To:** 'Chris Provencal'  
**Cc:** 'Marc Bellavance'; 'Mike Petsche'; 'Dan Stow'  
**Subject:** RE: Wearplate photos

No ... ship the wearplates.

David

---

**From:** Chris Provencal [mailto:cprovencal@dartaero.com]  
**Sent:** Wednesday, September 29, 2010 12:00 PM  
**To:** 'David Shepherd'  
**Cc:** 'Marc Bellavance'; 'Mike Petsche'; 'Dan Stow'  
**Subject:** RE: Wearplate photos

David,

I am signing off the wearplates based on Rev. A of the dwgs, with the deviation that the wearplates are 0.150 wider. Additionally, on the fwd wearplate, one tab is shifted 0.050" aft, and another tab is shifted .150" aft. This is a minor, non-structural, change to improve fit on the skidtube.

On that basis, do you have any objection to shipping the wearplates today?

-Chris

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**From:** Dan Stow [mailto:dstow@dartaero.com]  
**Sent:** September 29, 2010 12:54 PM  
**To:** 'Mike Petsche'  
**Cc:** 'David Shepherd'; Chris Provencal; 'Marc Bellavance'  
**Subject:** FW: Wearplate photos  
**Importance:** High

Mike,

Can I tell the customer that we are shipping the wearplates today?

Dan

Hello Francesco,

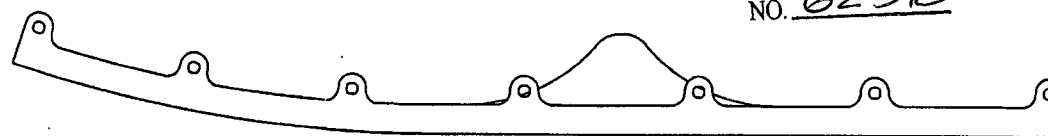
Please see the response from engineering below.

Regards,

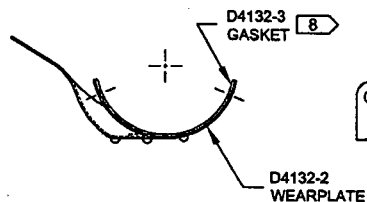
Dan Stow  
Technical Support  
Dart Aerospace Ltd.  
[dstow@dartaero.com](mailto:dstow@dartaero.com)

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X	X	D4132-041	WEARPLATE, LH FWD
	X	D4132-042	WEARPLATE, RH FWD
1		D4132-1	WEARPLATE
1	1	D4132-2	WEARPLATE
1	1	D4132-3	GASKET
A/R	A/R	1300 / 1300L	3M SCOTCH-GRIP ADHESIVE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 62318



D4132-041 WEARPLATE, LH FWD



D4132-042 WEARPLATE, RH FWD

**RELEASED**  
2010-06-29  
JAP

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4132-xxx" USING YELLOW PAINT MARKER ON INSIDE SURFACE
- 7) WEIGHT: -041/-042 = 2.1 lbs
- 8) BOND D4132-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

A	NEW ISSUE	CP	10.06.15
REV.	DESCRIPTION	BY	DATE
DESIGN	92		
DRAWN	92		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.06.15		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA  
DRAWING NO. REV. A  
D4132 SHEET 1 OF 6  
TITLE SCALE  
WEARPLATE, FWD NTS

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